

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006785**Date Inspected:** 13-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Wei Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Cross Beam 1 exterior and the upper interior of Segment 5BE after grit blasting. Areas that required repair marked and recorded.

Numerous Arc Strike areas were marked for grinding. Magnetic Particle testing of Arc Strike areas after grinding was not performed by ZPMC personnel.

Bay 2-

QA Inspector observed the following work in progress: FCAW welding of weld joint 160 located on OBG 1AAW SEG1C. ZPMC welder was identified as 045209. ZPMC QC is identified as Wu Zhi Cheng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

QA Inspector observed the following work in progress: FCAW welding of weld joint 192 located on OBG 2AAW, SEG2C. ZPMC welder was identified as 045240. ZPMC QC is identified as Wu Zhi Cheng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Bay3-

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member are identified as FB024-006, FB023-007 and FB020-009. The weld identification number is as follows: FB024-006-148, FB023-007-148 and FB020-009-078, 081 and 101.

QA Inspector observed the following work in progress: FCAW welding of weld joints 037, 038 located on OBG Floor beam FB014-042. ZPMC welder was identified as 204338. ZPMC QC is identified as Liu Wei Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 10-

QA Inspector observed the following work in progress: SMAW welding of weld joint SSD1-FASA4-1 A/E located on South Tower Skin Plate A for Lift 4 . ZPMC welders were identified as 040269 and 040582. ZPMC QC is identified as Tu Jun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4211-B-U3b-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversations occurred between QA and QC on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
